

Date: Thursday, 8/3/2006 8:10:18 AM
User: Chantal Lavoie

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 28087		
Estimate Number	: 12497		
P.O. Number	: N/A	Part Number	: D26179
This Issue	: 8/3/2006	Drawing Number	: D2617 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E. preliminary
Previous Run	: N/A	Material	: N/A
Written By	: <u>EC</u>	Due Date	: 8/10/2006
Checked & Approved By		Qty:	10 Um: Each
Comment	: Est A 06.07.25 New Issue KJ/JLM		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
			
Comment: Qty.: 0.0420 f(s)/Unit Total : 0.4200 f(s) Delrin Round Bar .50" Material: Delrin Round Bar Ø0.500" 6061 T6 .500" <i>(M-DELRIN-R0.500)</i>			
Identify as D26177 Batch: M101421 <i>STO 06/08/08</i> w			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: 1-TURN AS PER FOLIO FA & DWG D2617, FOLIO REV: N/A DWG REV: E <i>N/A Machined Manually</i>			
2-DEBURR AS REQUIRED <i>✓ J.A. 06/08/08</i> 10			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.F. 06/08/08</i> 10			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>J.F. 06/08/09</i> 10			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 <i>J.S. 06/08/08</i> 10			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/3/2006 8:10:18 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28087

Part Number: D26179

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG 06.08.09 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST53

AS
26/08/14 10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



C. Lavoie/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

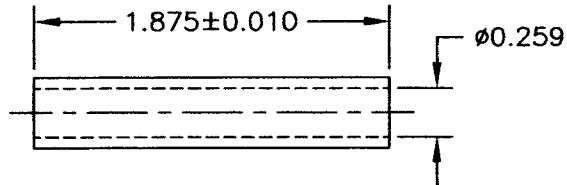
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

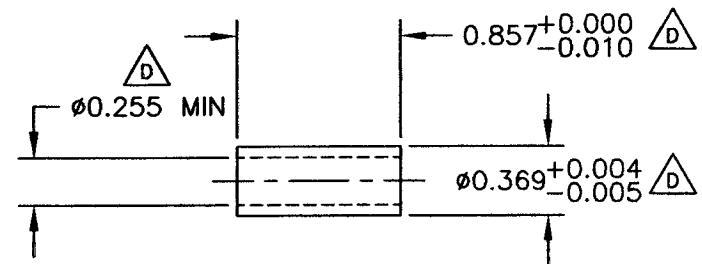
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN BW	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2617	REV. E SHEET 1 OF 1
DATE 06.07.25		TITLE BUSHING	SCALE 1:1
A	96.10.08	NEW ISSUE	
B	97.05.08	0.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE CORRECT TOL. (NCR779), ADD D2617-7	
E	06.07.25	ADD D2617-9	

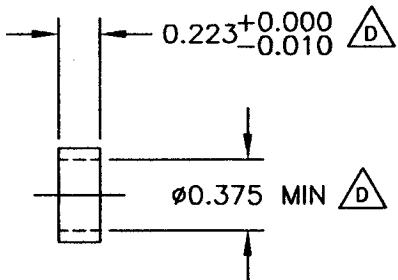


D2617-1 (MAT'L SPEC: SEE NOTE 1)

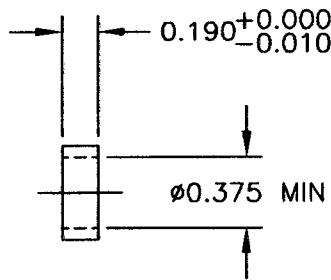


D2617-3 (MAT'L SPEC: SEE NOTE 1)

D2617-7 (DIM's SAME AS D2617-3,
FOR MAT'L SPEC: SEE NOTE 3)



D2617-5 (MAT'L SPEC: SEE NOTE 2)



E D2617-9 (MAT'L SPEC: SEE NOTE 2)

NOTES:

- 1) MATERIAL FOR D2617-1/-3: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
(REF. DART SPEC. M5052H32R0.375)
- 2) MATERIAL FOR D2617-5/-9: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
(REF. DART SPEC. M5052H32R0.500)
- 3) MATERIAL FOR D2617-7: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-R0.375)
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	28087
Description: Bushing	Part Number:	2617-9
Inspection Dwg: D2617 Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	06/08/08	Date:	06/08/09		Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	